Packaging

\$ P.

May-07-13 8:39:31 AM Item ID: D4009-3 Accept *N900040100* Setup Start **Revision ID:** Item Name: Ground Strap *10* **Start Date:** 5/07/13 **Start Qty: 10.00** Cust Item ID: Required Date: 5/14/13 Req'd Qty: 10.00 **Customer:** Reference: Run Date: 13-05-07 Tooling: Process Plan: MC5 Approvals: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Reject Accept Insp. Work Center ID Description **Run Hours** Code Qty Qty Number Stamp **Draw Nbr** Revision Nbr D4009 Α 100 0.00 *100* Small Fab 0.00 Memo Small Fab 1- Cut to size as per dwg D4009 110 QC5- Inspect part completeness to step on W/O 0.00 *110* 0.00 Memo Quality Control Identify as per dwg & Stock Location: 120 0.00 *120* Packaging 0.00 Memo

NCR: Y	'es	/ No				WORK ORDER NON-C	O	NFORM	/IANCE / UP	PDATE		QA Closed:	Dat	te:	
Work Orde	\r·				······	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part N	- lo					Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite				Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier			Engineering Quality Other
Root					Descri	ption of work order update		nitial	Ad	ction		Sign &			
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Landir	ng G	ear				General		_						_	•
	Bending					Bend		Grain				Ovalized			Pressure/Forced
	Centre Not Concentric to O/S					BOM/Route		Hardwa	re			Over/Under tolerance			Temperature/Cure
	Cracks					Broken/Damaged	Inspection Incomplete			7	Part Incorrect			Weld	

Instructions Incomplete/Unclear

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

DQA:

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Part Moved

Date:

Wrong Stock Pulled

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Cuffs

Heat Treat

Crushed/Crimped.

Inspection Strip in Tube

Torque Waves in Extrusion

Burrs

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish Folio

May-07-13 8:39:31 AM

Quality Control

101234

Page 2

Item ID: D4009-3 Accept *N900040100* Setup Start **Revision 1D:** Item Name: Ground Strap *10* **Start Date:** 5/07/13 **Start Qty: 10.00 Cust Item ID:** Required Date: 5/14/13 Req'd Qty: 10.00 **Customer:** Reference: Run Process Plan: Approvals: Date: **Tooling:** Date: Stop QC: SPC (Y/N): Date: Date: Sequence ID/ Operation Set Up/ Tool ID Reject Tool # Plan Accept Reject **Work Center ID** Description Run Hours Qty Qty Code Number Stamp 130 QC21- Final Inspection - Work Order Release 0.00 *130* 0.00 Memo

pl 13057

												DQA:	Da	ite:	
NCR:	Yes	/ No				WORK ORDER NON-C	100	VFORM	MANCE / UP	DATE				•	
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Work Orde	or.					DISPOSITION				PAF	RTMENT/	PROCESS			
WOIK OIG	=1.				<u> </u>	Rework	1	Skid-tube Crosstube			Water Jet				Engineering
Part N	No.					Scrap			Machining	Small Fab	Prod. Eng. Coor.			Quality	
	-					Use-as-is		Therm	noforming	Finishing]	Rec/Store	e/Packaging		Other
NCR No.			Work Order Update		Large Fab	Composite]		Supplier						
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Root						ption of work order update	1	nitial		ion	1	Sign &			
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Landi	ng G	iear				General		,			7				1
	Ш	Bending				Bend		Grain		<u> </u>	┥	alized		<u></u>	Pressure/Forced
		Centre No	t Concer	ntric to (o/s	BOM/Route	<u></u>	Hardwa	re		JOV	er/Under	tolerance	L	Temperature/Cure
	Cracks					Broken/Damaged		Inspecti	on Incomplete		Pai	rt Incorrec	et e		Weld
	Crushed/Crimped					Burrs		Instruct	ions Incomplete/l	Jnclear	Par	rt Lost/Mi	ssing		Wrong Stock Pulled
	Cuffs					Contamination		Mainte	nance		Pai	rt Moved			
		Heat Trea	t			Countersink		Mislabe	led		Po	sitioned W	√rong	_	
	Inspection Strip in Tube					Cut Too Short		Misread Power Loss/Surg					Surge		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

May-0"-13 N:39:35.1M

Work Order ID: 101234

101234

Parent Item:

D4009-3

D4009-3

Parent Item Name: Ground Strap

Start Date: 5/07/13

Required Date: 5/14/13

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP rev A 09.12.23 new Issue Prelim EC verified by: DD

IPP Rev:B

10.05.03 as per ECN10-562 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch		Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Status Issued
D4009		Manufactured	No			100	f	11.8750	0.125	1.25	0/	
D4009 Ground Strap									**		1513	105 107
·				Location		Loc C	<u>Oty</u>	Loc Code				
				GA	72538		875 875		-	1 -7 5	-	

										DQA:	Date	:
NCR:	Yes / N	o			WORK ORDER NON-	COI	VFORN	MANCE / UPDATE				
						,.				QA Closed:	Date	i. Tomas karas talah salah sa
Work Orde	ar·				DISPOSITION							
WOIR Old			,		Rework	٦		Skid-tube Crosstube			Water Jet	Engineering
Part I	No.				Scrap	Machining Small Fab			Pro	d. Eng. Coor.	Quality	
	<u>-</u> .		·		Use-as-is]	Therm	oforming Fini	shing	Rec/Sto	re/Packaging	Other
NCR No.					Work Order Update Large Fab Compos				osite		Supplier	
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Cause	Dat	e Step	Qty		or Non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
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Operator												
Material			İ									
Setup												
Other												
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					F	AUL	T CATE	GORY	 			
Landi	ng Gear			_	General	_	1		_	7	r	
	Bendi	_			Bend		Grain		ļ	Ovalized	<u> </u>	Pressure/Forced
		Not Conce	entric to	D/S	BOM/Route		Hardwa			Over/Under	<u> </u>	Temperature/Cure
	Cracks				Broken/Damaged		4	on incomplete		Part Incorre	 	Weld
	 -	ed/Crimped	l.	<u> </u>	Burrs	\perp	1	ons Incomplete/Unclear		Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	\perp	Mainte			Part Moved		
	Heat T	reat			Countersink		Mislabe	led		Positioned V		_
	Inspec	tion Strip ir	n Tube		Cut Too Short		Misread			Power Loss/	Surge	Other
	Ripple	s in Bend			Drill Holes		Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

FEM NO	Q17. -041	o, or NUMBER	DESCRIPTION	JOHN CAMERON AVIA JON FART NUMBER
1	X	D4009-041	BONDING BRAID	JCA-M47-4-01
2	2	D4009	TERMINAL END	
3	1	D4009-3	GROUND STRAP	
4	1	D4009-5	GROUND STRAP	
5	1	D4009-7	TAB	
6	1	D4009-9	RECEPTACLE	

ENGINE R. . . G UNCONTROLLED COPY SUBJECT TO AMUNDMENT WITHOUT NUTICE WORK ORDER NO_101234MC= 13-05-07

D4009-041 BONDING BRAID

С

С

NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4009-041" AND B/N USING D2729-1 LABEL INSTALLED WITH D2182-045 HEAT SHRINK
7) WEIGHT: N/A
8) USE CRIMPING TOOL P/N 59824-1

Α NEW ISSUE 10.02.05 REV. DESCRIPTION DATE ΒY DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN CHECKED DRAWING NO. REV. A D4009 MFG. APPR. SHEET 1 OF 5 TITLE APPROVED SCALE DE APPR. **GROUND STRAP** DATE 10.02.05

Sec 27 OT: TO

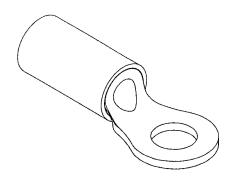
UPDATE QA Closed:	Date:	Strange for the state of the strange for the state of the							
AGAINST DEPARTMENT/PROCESS									
	· ·	Engineering Quality Other							
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	QA Closed: AGAINST DEPARTMENT/ Crosstube Small Fab Prod Finishing Rec/Stor Composite Action Sign &	AGAINST DEPARTMENT/PROCESS Crosstube Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier Action Sign &							

Landing Gear General Pressure/Forced Bend Grain Ovalized Bending Temperature/Cure BOM/Route Over/Under tolerance Centre Not Concentric to O/S Hardware Weld Part Incorrect Cracks Broken/Damaged Inspection Incomplete Wrong Stock Pulled Part Lost/Missing Crushed/Crimped. Instructions Incomplete/Unclear Burrs Part Moved Maintenance Cuffs Contamination Positioned Wrong Heat Treat Mislabeled Countersink Other Power Loss/Surge Inspection Strip in Tube Cut Too Short Misread Drill Holes Ripples in Bend Offset Out of Calibration Torque Waves in Extrusion Drawing Turning Sequence Out of Sequence Finish Folio Wave/Twist in Tube Outside Dimensions

FAULT CATEGORY

Supplier Training Unapproved

SPECIFICATION CONTROL DRAWING



DART PART NUMBER	SUPPLIER	SUPPLIER PART NUMBER	MILITARY PART NUMBER	INSTALLATION TOOL PART NUMBER
D4009-1	TYCO ELECTRONICS	36161	MS25036-112	59824-1

D4009-X TERMINAL END



NOTES.
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: N/A

DESIGN	85	DART AEROSPAC	FITD							
DRAWN	1	HAWKESBURY, ONTARIO, CANADA								
CHECKED	B	DRAWING NO.	REV. A							
MFG. APPR.	E	D4009	SHEET 2 OF 5							
APPROVED	NP.	TITLE	SCALE							
DE APPR.	-14	GROUND STRAP	NTS							
DATE 10.0	2.05	COPYRIGHT @ 2010 BY DART AEROSPACE LTD THIS DOCUMENT'S PRIVATE AND CONFIDENTIAL AND IS SUPPLED ON THE EXPRESS COMMON THAT IT IS NOT TO SELECT OF ANY PURPOSE ON COMPANIENT TO ANY OTHER PERSON WITHOUT WORTH HE PRIVASSORY HOW DURTH REPORTED.								

									DQA:	Date:	
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									QA Closed:	Date:	And the second s
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Part No	0.				Scrap	1 1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
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Hardware

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Inspection Incomplete

Instructions Incomplete/Unclear

BOM/Route

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish Folio

Burrs

Broken/Damaged

Temperature/Cure

Wrong Stock Pulled

Weld

Other

Over/Under tolerance

Part Incorrect

Part Moved

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Cracks

Cuffs

Heat Treat

Crushed/Crimped.

Inspection Strip in Tube

Torque Waves in Extrusion

Centre Not Concentric to O/S

LART AEROSPACE PART NUMBER JOHN CAMERON AVIATION , PART NUMBER REF JCA M47-4-01 REF JCA- 447-4-01 D4009-3 D4009-5

SPECIFICATION CONTROL DRAWING

DART PART NUMBER	LENGTH
D4009-3	1.5
D4009-5	13.5

D4009-X GROUND STRAP



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NOTES:
1) MATERIAL: MADE FROM AVIALL P/N 1171 (OR SEA-171) OR C.O.R.E. AVIATION P/N QQ8575R36T250
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: N/A

DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN CHECKED DRAWING NO. REV. A D4009 MFG. APPR. SHEET 3 OF 5 APPROVED TITLE SCALE **GROUND STRAP** DE APPR. NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD
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EED FOR ANY PUMPOSE ON COMED OR COMMANDATED TO ANY OTHER PERSON
SEED FOR ANY PUMPOSE ON COMED OR COMMANDATED TO DATE 10.02.05

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											QA Closed:	Dat	e:	
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Work Orde	=1					Rework	1		Skid-tube Crosstube			Water Jet		Engineering
Part N	No.					Scrap		Machining Small Fab			Prod. Eng. Coor.			Quality
						Use-as-is	Therm	noforming Finishi	ing	Rec/Stor	re/Packaging		Other	
NCR No.						Work Order Update Large Fab Composite				ite	Supplier			
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Equip/Tooling												-		
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Material													İ	
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	∐В•	ending			<u> </u>	Bend		Grain		<u> </u>	Ovalized			Pressure/Forced
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	L C	racks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	-	Weld
	Crushed/Crimped					Burrs		Instruct	ions Incomplete/Unclear	L	Part Lost/M	issing	\	Wrong Stock Pulled
	∐]Cı	uffs				Contamination		Mainte	nance		Part Moved			
	Шн	eat Trea	t			Countersink		Mislabe	led		Positioned V	V rong		
	∐_]in	spection	Strip in	Tube		Cut Too Short		Misread	1		Power Loss/	'Surge		Other
	Ri	Ripples in Bend				Drill Holes		Offset						

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence
Wave/Twist in Tube

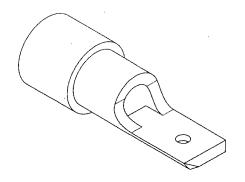
Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

SPECIFICATION CONTROL DRAWING



DART PART NUMBER	SUPPLIER	SUPPLIER PART NUMBER	INSTALLATION TOOL PART NUMBER		
D4009-7	TYCO ELECTRONICS C.O.R.E. AVIATION	8-696372-1	59824-1		

D4009-X TAB



С

NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: N/A

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DESIGN DRAWN DRAWING NO. D4009 CHECKED REV. A MFG. APPR. APPROVED TITLE SCALE GROUND STRAP DE APPR. COPYRIGHT 6 2010 BY DART AEROSPACE LTD

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NOT TO BE USED FOR HIM FURNOSE OR CONDITION OF COMPANIESTED ON TO THERE PERSON WITHOUT
WITH THE PERSON FROM DART ARROWNED LTD. DATE 10.02.05

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SHEET 4 OF 5

											DQA:	Date:	
NCR:	Yes /	No				WORK ORDER NON-	100	VFOR	MANCE / UPDATE		OA Clasad	Date	
									NO.		QA Closed:	Date	
						DISPOSITION		T DE	EPARTMENT/PROCESS				
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Part N	do.					Scrap	1]		Machining Small Fa	_	Prod	d. Eng. Coor.	Quality
raiti	···					Use-as-is	Thermoforming Finishing				Rec/Stor	Other	
NCR 1	No.					Work Order Update	1		Large Fab Composit	~	,	Supplier	
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Root			-		Descri	ption of work order update	1	Initial	Action		Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspector
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	Bending Centre Not Concentric to O/S					BOM/Route	\vdash	Hardware			Over/Under tolerance		Temperature/Cure
	⊢		it concei	itile to	^{0/3} -	Broken/Damaged	\vdash	Inspection Incomplete			Part Incorre) -	Weld
	Cracks Crushed/Crimped					Burrs	-	Instructions Incomplete/Unclear			Part Lost/Mi	 	Wrong Stock Pulled
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	Heat Treat					Countersink		Mislabe			Positioned V	Vrong	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Cut Too Short Drill Holes

Drawing

Finish Folio Power Loss/Surge

Other

Ripples in Bend

Turning Sequence

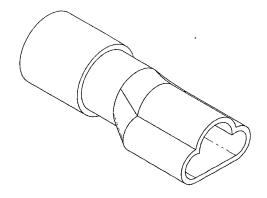
Wave/Twist in Tube

Inspection Strip in Tube

Torque Waves in Extrusion

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

SPECIFICATION CONTROL DRAWING



DART PART NUMBER	SUPPLIER	SUPPLIER PART NUMBER	INSTALLATION TOOL PART NUMBER		
D4009-9	TYCO ELECTRONICS C.O.R.E. AVIATION	8-696371-1	59824-1		

D4009-X RECEPTACLE



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NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: N/A

DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN CHECKED DRAWING NO. REV. A D4009 MFG. APPR. SHEET 5 OF 5 APPROVED TITLE SCALE GROUND STRAP

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				•							DQA:	Date	:		
NCR:	Yes	/ No				WORK ORDER NON-C	COL	NFORI	MANCE / UP	DATE	OA Clasad	Data			
											QA Closed:	Date	· · · · · · · · · · · · · · · · · · ·		
Work Order:						DISPOSITION		AGAINST DEPARTMENT/PROCESS							
VVOIR OIG	٠					Rework	Skid-tube Crosstube]	Water Jet	Engineering			
Part f	No.					Scrap		Machining Small Fab			Pro	d. Eng. Coor.	Quality		
Part No.						Use-as-is	Thermoforming Finishing			Finishing	Rec/Sto	e/Packaging	Other		
NCR I	No.					Work Order Update	Large Fab Composite			Composite]	Supplier			
								L							
Root					I	ption of work order update		nitial		tion	Sign &				
Cause	,	Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector		
Doc/Data												:			
Equip/Tooling					 										
Operator	Ш											:			
Material						-									
Setup	Ш														
Other	Ш														
Process															
Supplier															
Training	Ш														
Unapproved					ļ.,		<u> </u>					<u> </u>	_1		
						F.	AUL	T CATE	GORY						
Landi	ng (Gear			_	General		,		_	,	۲-	-		
	-	Bending				Bend	L.	Grain		_	Ovalized	-	Pressure/Forced		
		Centre No	ot Conce	ntric to	O/S	BOM/Route	_	Hardware			Over/Under	⊢	Temperature/Cure		
		Cracks				Broken/Damaged		Inspection Incomplete			Part Incorre	<u> </u>	Weld		
		Crushed/	Crimped.	-		Burrs		Instructions Incomplete/Unclear			Part Lost/M	issing	Wrong Stock Pulled		
	\vdash	Cuffs				Contamination		Maintenance			Part Moved				
	Heat Treat					Countersink		Mislabeled			Positioned \		_		
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	t		Power Loss	Surge	Other		
		Ripples in	Bend			Drill Holes		Offset							
	Torque Waves in Extrusion				n [Drawing		Out of	Calibration	·					

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G